

Work Order ID 80952

March-06-12 8:54:28 AM

80952

Page 1

Item ID: D206-642-151

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube

Start Date: 06/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 20/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/06 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3804

A

IIN-D206-642

O

0.00

100

DOCUMENT CONTROL

DC:

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D206-642-151

CHG001

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

110

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Deburr Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804

3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod *M12064*

4-Grind weld flush to cap on top surface only

5-Cut Aft end as per dwg D3804 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804

7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt8166 & DT8169D & DT9771.

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 30 drill, spot drilling doubler at the same time.

*CF 12-4-23**CF 12-5-1**SAD 12-05-01*

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Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D3804

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D3804

15-C'sink GHW rivet holes as per Dwg D3804

16- Open Aft cap hole #6.
****no wearplate holes for this skidtube****

17-Deburr tube and blow out chips from inside the tube

SAD 12.05-01

rx 12/05/10

0.00

0.00

8/10/10

120

120

QC

Quality Control

QC6- Inspect dimensions to drawing

Memo

W/O:		WORK ORDER CHANGES					
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Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

MG 12-5-10

150

QC7-Inspect Chemical Conversion Coat

0.00

150

QC

Memo

0.00

Quality Control

① SAD 12-05-11

160

Skidtubes

0.00

160

Skidtubes

Memo

0.00

Skidtubes

1-Open holes to finished size as per Dwg D3804, (without cutting fluid)

2-C'sink crossbolt spacer holes as per Dwg D3804(without cutting fluid)

3-Deburr and blow out all chips from inside the tube

① SAD 12-05-11

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Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

QC6- Inspect dimensions to drawing

0.00

170

QC

Memo

0.00

Quality Control

1 0 BE12-05-11

180

0.00

180

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required

2-Bond D2654-1 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

Start Date: 12-05-14 Time: 3:00

Finish Date: 12-05-15 Time: 10:00

Pick:

Qty Part Number Description Batch

A/RSikaflex-291 M121221

Sikaflex expire date: 2013-01-04

① SAA 12-03-14

CC
SAA 12-03-14

W/O:		WORK ORDER CHANGES					
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1

Customer:

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

1 0 BE 12/05/15

W/O:		WORK ORDER CHANGES					
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1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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200

0.00

200

Skidtubes

Skidtubes

Memo

0.00

1-remove alodine from around hole and prepare for welding

2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

QtyPart NumberDescriptionBatch

A/RAluminum Rod

M120164

3-Grind welds flush as per Dwg D3804.

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/RSS Rod NONEBE 12-05-16

5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D3804. Deburr

BE 12-05-15

CK/CC 12-5-15

NP 12-5-23

W/O:		WORK ORDER CHANGES					
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80952

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N900040100

Setup Start *NS1*

Stop *NS2*

*** 1 ***

*** 1 ***

Customer:

Run Start *NR1*

Stop *NR2*

Insp. Stamp

0.00

HandFinishing

0.00

Memo

Install D2680-041 Nut Plate as per Dwg D3804

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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Item Name: Replacement Skidtube

Stop ***NS2***

Start Date: 06/03/2012 Start Qty: 1.00

1

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Required Date: 20/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	QC5- Inspect part completeness to step on W/O	0.00							
230									
QC	Memo	0.00							
Quality Control									
240	Pressure Wash per QSI005 4.3	0.00							
240									
HandFinish	Memo	0.00							
Hand Finishing									
250	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
250									
Powdercoat	Memo	0.00							
Powder Coating									

M121134

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:30
320°F
10:00

1 26 12-5-29

IX 0 M-L 12/05/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	QC3- Inspect Part Finish	0.00							
260									
QC	Memo	0.00							
Quality Control									
270		0.00							
270	HandFinishing								
HandFinish	Memo	0.00							
Hand Finishing	1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804. Clean excess adhesive.								

W/O:		WORK ORDER CHANGES					
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N900040100

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NS1

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NS2

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Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

280

0.00

280

HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive

A/RSikaflex-291 1111409

Sikaflex expire date: 13103

2- Install wearplate as per dwg

2-Wing Walk as per Dwg D3804 and QSI 005 4.4

Batch: 1112550

124 1111409 13103

290

QC3- Inspect Part Finish

0.00

290

QC

Memo

0.00

Quality Control

1112550

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SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
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Run Hours

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Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

300

QC5- Inspect part completeness to step on W/O

0.00

300

QC

Memo

0.00

Quality Control

8/17/06/15

310

Packaging

0.00

310

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-642-151

Location:

PPP Rev:

PPP 87028

320

QC21- Final Inspection - Work Order Release

0.00

320

QC

Memo

0.00

Quality Control

12/7/11 @

ML5 12/07/12

ML5 12/07/12

W/O:		WORK ORDER CHANGES					
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Picklist Print

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80952

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 06/03/2012

Required Date: 20/03/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 10.12.08 PER IIN REV.N DD VERF:EC
REV:B 11.09.16 PER IIN REV.O DD VERF:EC

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2620

Manufactured

No

110

Each

19.0000

1

1

D2620

Skidtube, 206 Skidtube

B82517

**

① 12-04-12

Location

Loc Qty

Loc Code

LG

19

77996

1

77999

1

78000

4

79542

1

79543

2

79544

8

79545

2

D2647

Manufactured

No

110

Each

57.0000

1

1

D2647

Cap

**

Location

Loc Qty

Loc Code

LG002

57

75482

57

B79563 01

W/O:		WORK ORDER CHANGES					
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D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 06/03/2012

Required Date: 20/03/2012

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-04

Purchased

No

180

Each

7,125.000

52

52

CR3212-4-04

Cherry Rivet

**

SAD 12-05-14

Location

Loc Qty

Loc Code

ST331

168

116471

78

117816

3

118686

1

118840

16

119017

60

119075

10

st510

6957

119075

6957

D2654-1

Manufactured

No

180

Each

23.0000

1

D2654-1

Web

**

52
SP/CC 12-5-14

Location

Loc Qty

Loc Code

LG

23

79540

5

79541

6

80054

2

80055

10

79538 →

①

D3286-1

Manufactured

No

180

Each

121.0000

2

2

D3286-1

Doubler

**

SAD 12-03-01

Location

Loc Qty

Loc Code

LG002

217

74872

6

78014

93

ST046

-96

76772

22

B79556

②

March-06-12 8:54:32 AM

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Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-06-12 8:54:32 AM

Page 3

Work Order ID: 80952

80952

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 06/03/2012

Required Date: 20/03/2012

Start Qty: 1.00

Required Qty: 1.00

D2649

Manufactured No

200

Each

1,736.000

19

19

D2649

Cross Bolt Spacer

**

BE12-05-15

Location

Loc Qty

Loc Code

LG

1279

77574

2

79502

403

79503

399

79504

214

79565

261

LG001

457

65317

1

68224

2

68507

11

71355

2

72704

2

72841

11

73390

8

73857

21

73858

53

73859

4

73860

4

78020

6

78583

2

79566

330

19

D3286-3

Manufactured No

200

Each

113.0000

2

2

D3286-3

Spacer

**

BE12-05-15

Location

Loc Qty

Loc Code

LG

9

78015

9

LG001

104

74117

1

79557

103

2

March-06-12 8:54:32 AM

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Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

March-06-12 8:54:32 AM

Page 4

Work Order ID: 80952

80952

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 06/03/2012

Required Date: 20/03/2012

Start Qty: 1.00

Required Qty: 1.00

D2680-041

Manufactured No

210 Each

158.0000

1 1

D2680-041

Nut Plate

**

CF 12-5-23

Location

Loc Qty

Loc Code

ST013

116

78016

116

ST019

42

76790

42

CR3212-4-03

Purchased No

210 Each

1,484.000

2 2

CR3212-4-03

Cherry Rivet

**

CF 12-5-23

Location

Loc Qty

Loc Code

FP002

494

114859

494

ST331

990

110139

2

119017

988

AN960JD416

NAS1149D0463J

Purchased No

210 Each

20.0000

1 1

AN960JD416

Washer

11121255 **

(x.1) 12/05/31

Location

Loc Qty

Loc Code

ST351

20

116289

20

CCR264SS3-3

Purchased No

210 Each

723.0000

2 2

CCR264SS3-3

Cherry Rivet

**

CF 12-5-23

Location

Loc Qty

Loc Code

ST331

723

113973

2

117849

125

119017

596

March-06-12 8:54:33 AM

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 5

Work Order ID: 80952

80952

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 06/03/2012

Required Date: 20/03/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039-4-06

Purchased

No

210

Each

204.0000

1

1

MS27039-4-06

Screw

**

HL 12/05/31

Location

Loc Qty

Loc Code

ST292

204

119075

204

D2651-1

Manufactured

No

270

Each

749.0000

6

6

D2651-1

Plug

**

HL 12/05/31

Location

Loc Qty

Loc Code

FP001

884

B81954

x6

57869

1

66445

10

69018

2

70827

2

70839

8

71037

8

77559

30

78584

245

79234

278

FP-A

-135

77559

1

78124

164

D2651-3

Manufactured

No

270

Each

2,017.000

6

6

D2651-3

O-Ring

**

HL 12/05/31

Location

Loc Qty

Loc Code

FP001

89

61962

12

73828

77

FP-A

1928

78126

1928

x6

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Page 5

W/O:		WORK ORDER CHANGES					
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Picklist Print

March-06-12 8:54:33 AM

Page 6

Work Order ID: 80952

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

80952

D206-642-151

Start Date: 06/03/2012

Required Date: 20/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3873-1

Manufactured No

280

Each

431.0000

14

14

D3873-1

Bushing

**

yl 12/05/13

Location

Loc Qty

Loc Code

ST057

372

79561

372

ST067

59

64760

1

68247

4

73829

19

73830

2

79560

33

yl

D2646

Manufactured No

280

Each

50.0000

1

1

D2646

Aft Cap

**

yl 12/05/11

Location

Loc Qty

Loc Code

FP002

50

62678

5

68280

5

70945

1

71070

2

73294

1

73825

2

78018

34

yl

D3805-041

Manufactured No

280

Each

8.0000

1

1

D3805-041

Wearplate Assembly Fwd, Low Gear

**

yl 12/05/13

Location

Loc Qty

Loc Code

FP001

8

76779

1

78003

7

1378006

xl

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 7

Work Order ID: 80952

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

80952

D206-642-151

Start Date: 06/03/2012

Required Date: 20/03/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-08

Purchased

No

280

Each

1,243.000

2

2

MS27039-1-08

Screw

**

12/05/31

Location

Loc Qty

Loc Code

ST291

1243

117423

81

119075

156

119109

6

120308

1000

X2

MS21042L3

Purchased

No

280

Each

3,643.000

7

7

MS21042L3

Nut

**

12/05/31

Location

Loc Qty

Loc Code

ST300

3643

117441

16

117885

32

118451

5

118927

3

119017

3407

119075

180

X7

D3805-045

Manufactured

No

280

Each

14.0000

1

1

D3805-045

Wearplate Assembly Aft, Low Gear

**

12/05/21

Location

Loc Qty

Loc Code

FP001

14

B81426

73817

1

74896

1

78010

2

78011

10

X1

AN960JD10L

NAS1149D0332J

Purchased

No

280

Each

0.0000

2

2

AN960JD10L

Washer

**

11/12/01

12/05/31

March-06-12 8:54:33 AM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

March-06-12 8:54:33 AM

Page 8

Work Order ID: 80952

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

80952

D206-642-151

Start Date: 06/03/2012

Required Date: 20/03/2012

Start Qty: 1.00

Required Qty: 1.00

AN3-37A

Purchased

No

280

Each

790.0000

7

7

AN3-37A

Bolt

**

HL 12/05/13

Location

Loc Qty

Loc Code

ST353

790

117619

4

119086

786

NAS1149D0363J

Purchased

No

280

Each

2,181.000

7

7

NAS1149D0363.J

Washer

**

HL 12/05/13

Location

Loc Qty

Loc Code

ST298

2181

117601

61

118077

1

118612

18

119537

257

120142

274

120308

570

120644

1000

Y7

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	Qty -041	Qty -043	Part Number	Description
1	X		D3804-041	SKIDTUBE ASSEMBLY, 206 A/B LOW
2		X	D3804-043	SKIDTUBE ASSEMBLY, 206 A/B HIGH
5	1	1	D2600-1-160	EXTRUSION
6	1	1	D2646	AFT CAP
7	1	1	D2647	CAP
8	19	20	D2649	CROSS BOLT SPACER
9	6	8	D2651-1	PLUG
10	6	8	D2651-3	O-RING
11		1	D2654-3	WEB
12	1		D2654-1	WEB
13	1	1	D2680-041	NUT PLATE
14	2	2	D3286-1	DOUBLER
15	2	2	D3286-3	STUD
21	2	2	AN960JD10L	WASHER
22	1	1	AN960JD416	WASHER
23	2	2	CCR264SS3-3	RIVET
24	2	2	CR3212-4-03	RIVET
25	52	52	CR3212-4-04	RIVET
26	2	2	MS27039-1-08	SCREW
27	1	1	MS27039-4-06	SCREW

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 80952 HLTJ

12/03/06

RELEASED
UP 09.07.07
PC ECN 09-598

A	NEW ISSUE	MB	08.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>99</u>	DART AEROSPACE USA, INC	
DRAWN	<u>99</u>	PORT HADLOCK, WA	
CHECKED	<u>99</u>	DRAWING NO.	REV. A
MFG. APPR.	<u>99</u>	D3804	SHEET 1 OF 5
APPROVED	<u>99</u>	TITLE	SCALE
DE APPR.	<u>99</u>	SKIDTUBE ASSEMBLY, 206A/B	NTS
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W/O:		WORK ORDER CHANGES					
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DESIGN	99	DART AEROSPACE USA, INC	
DRAWN		PORT HADLOCK, WA	
CHECKED	99	DRAWING NO.	REV. A
MFG. APPR.	99	D3804	SHEET 2 OF 5
APPROVED	99	TITLE	SCALE
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

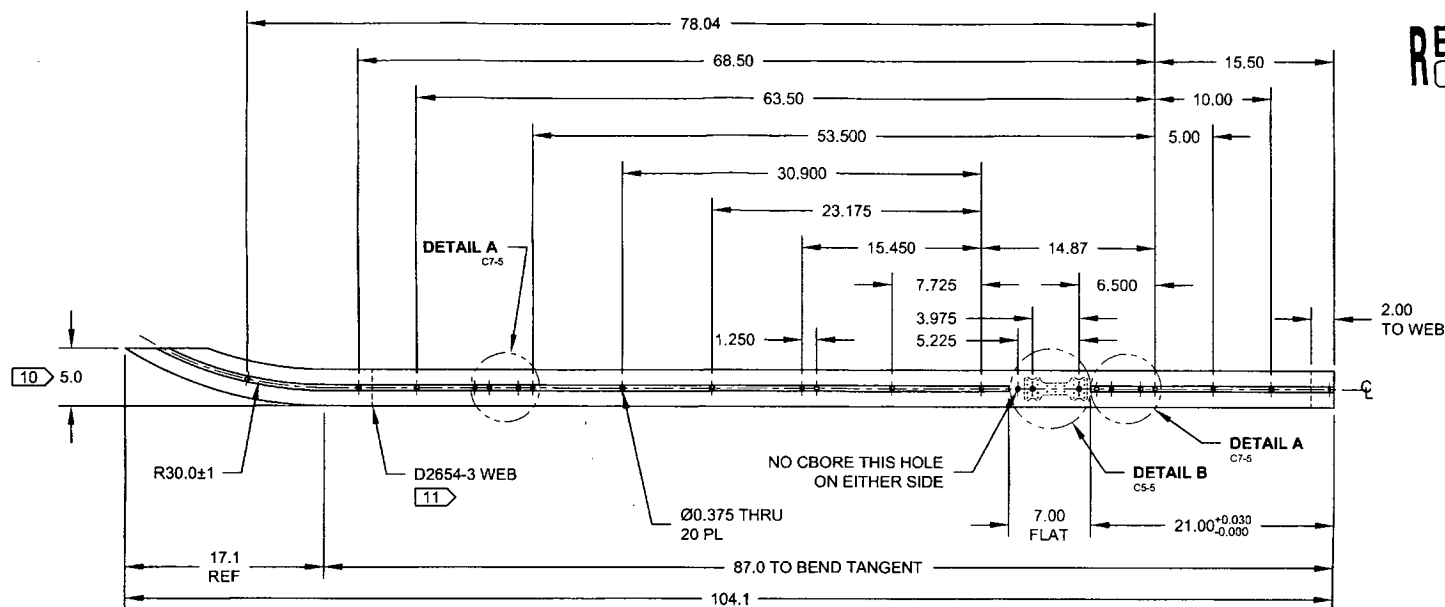
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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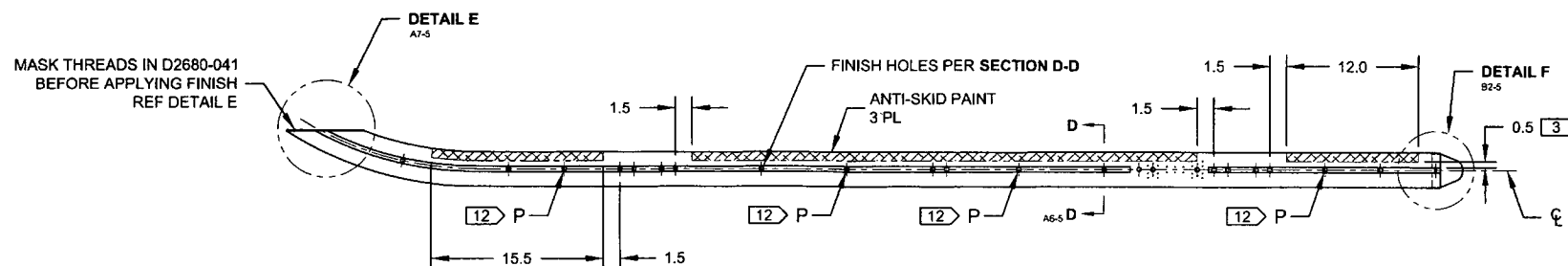
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09.03.03

80952



D3804-043 BENDING/DRILLING DETAIL



D3804-043 ASSEMBLY/FINISHING DETAIL

DESIGN	91	DART AEROSPACE USA, INC	
DRAWN	91	PORT HADLOCK, WA	
CHECKED	91	DRAWING NO.	REV. A
MFG. APPR.	91	D3804	SHEET 3 OF 5
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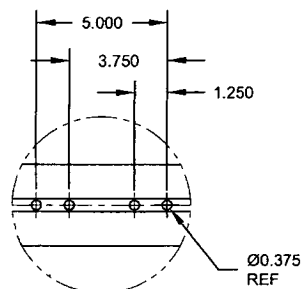
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

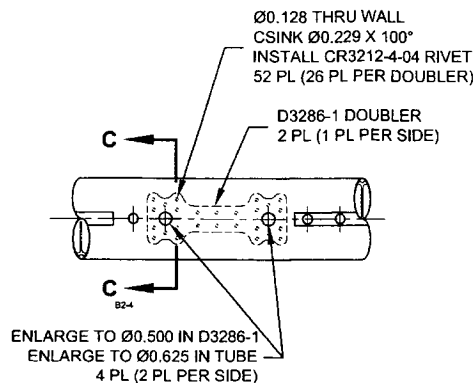
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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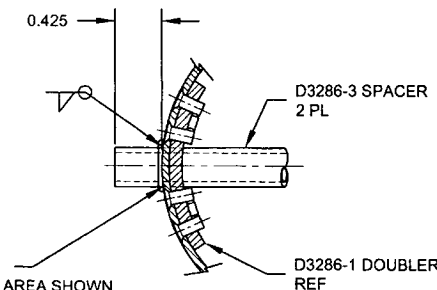
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DETAIL A
SCALE NONE
D6-2
C2-2
D6-3
C2-3

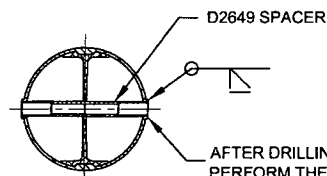


DETAIL B
SCALE NONE
C3-2
C3-3



- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH

SECTION C-C
PARTIAL SECTION
SCALE NONE
C6-4



- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.03 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. CBORE TO Ø0.313 X 0.75 DP (EXCEPT WHERE INDICATED)

SECTION D-D
FOR Ø0.375 HOLES ONLY
SCALE NONE
A4-2
A4-3

DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	J	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	B	D3804	SHEET 4 OF 5
APPROVED	97	TITLE	SCALE
DE APPR.	97	SKIDTUBE ASSEMBLY, 206A/B	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

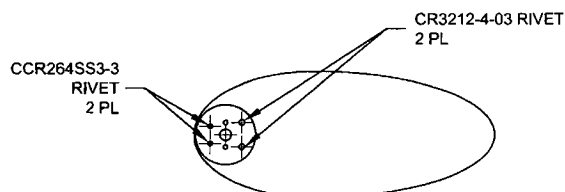
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

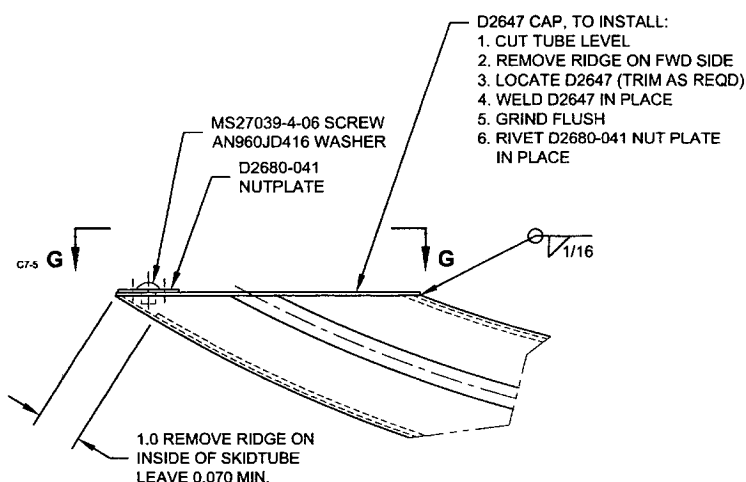
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97 09 03 07

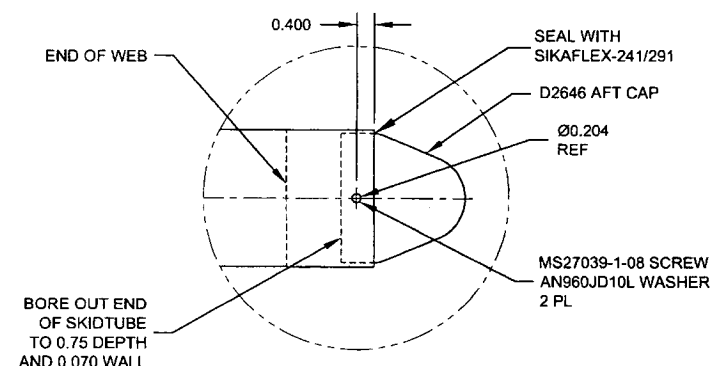
80952



VIEW G-G
SCALE NONE A7-5



DETAIL E
SCALE NONE B7-2 B7-3



DETAIL F
SCALE NONE B2-2 B2-3

DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	J	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO. D3804	REV. A
MFG. APPR.	97	SHEET 5 OF 5	
APPROVED	97	SCALE	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 295

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 83028
Part number: A206-642-241
Description: Skid tube
Welding Process: Tig[☒] Mig[]
Base material: Alum.
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:
Penetration:

pass[☒] fail[]
pass[☒] fail[]

UNACCEPTABLE

Cracks:
Undercut:
Pin holes:
Overlap (cold lap)
Porosity (surface):
Coloration:

pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]

Qualifier [Signature]

Date of Test Coupon 12.05.23

Welder Barclay Elliott

Date of Test Coupon 12.05.23

The above named individual is qualified in accordance with AWS D17.1.2001 to weld